

5/46

DART AEROSPACE LTD	Work Order:	24706
Description: Bracket	Part Number:	D3156-1
Dwg: D3156 Rev. B	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10	J.L.	05.10.26	4
2	MV	Cut blank: 1.950" x 0.700" grain along 1.950" Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Identify for D3156-1 Batch: M17225	J.L.	05.11.12	10
3	MV	Machine as per Folio FA477 and Dwg D3156 Stack of 10 Identify as D3156-1	J.L.	05.11.13	10
4	QC2	Inspect parts as they come off the CNC machine	J.L.	05.11.13	10
5	QC8	Second check	J.L.	05.11.13	10
6	GA	Deburr	SAD	05/11/13	10
7	GA	Form as per Dwg D3156	SAD	05/11/14	10
8	QC5	Inspect work to Step 7	SAD	05.11.14	10
9	FP	Chemical Conversion Coat as per QSI 005 4.1	SAD	05/11/19	10
10	QC3	Inspect Chemical Conversion Coat	SAD	05/11/21	10
11	ST	Identify with part number and batch number using fine point permanent ink marker, and Stock LOC: 402	DL	05/11/21	10
12	AC	Cost / part: 48	SAD	05-11-23	10
13	DC	Close W/O 5.97 Inspect Level 21	J.L.	05/11/23	10

Rev	Date	Change	Revised By	Approved
A	04.11.30	New issue	KJ/JLM	

RELEASED
01/01/12-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 05/11/23
 QA: N/C Closed: _____ Date: _____

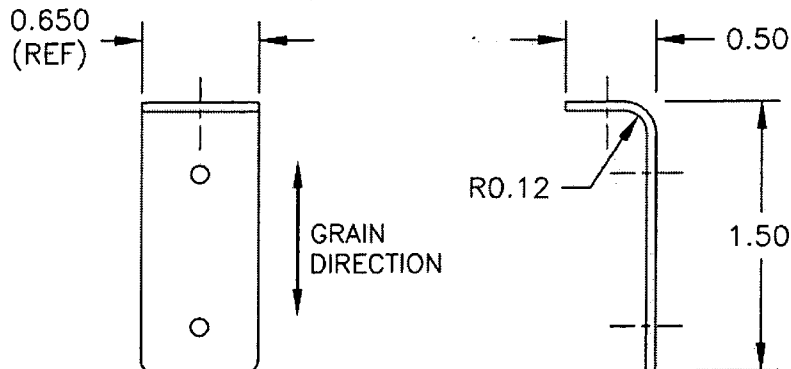
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

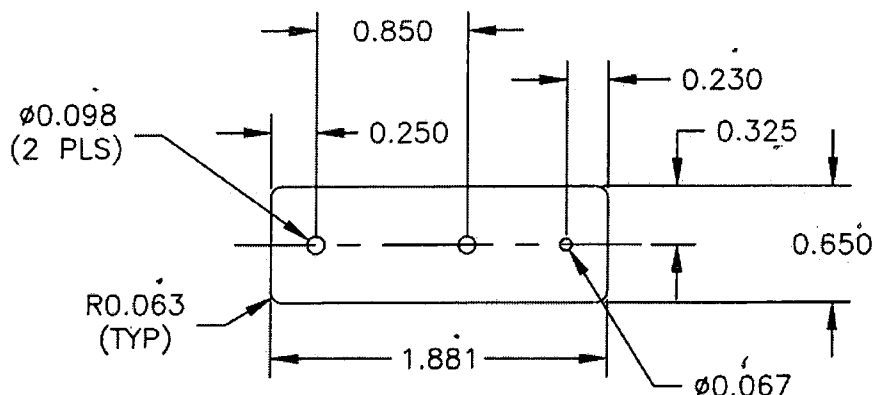


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3156	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE BRACKET	SCALE 1:1
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

RELEASED
04.11.23



D3156-1 BRACKET



D3156-1 BRACKET FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-117
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

COPY
TURN TO
ENGINEERING

13
FIC

WORK CENTER
NO 24706

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 26, 2005
03:12 pm

Work Order No	: 0024706	Department Code:	
Project Name	: D3156-1	Burden Flags	: NNNNNNN
Project For	: WK546	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D3156-1	Invoice Number	:
Description	: Bracket	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 4	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 10-26-05		
Est Finish Date	: 11-15-05	Est Mark Up	: 0.000%
Act Finish Date	:	Actual Mark Up	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

Date: Wednesday, 11/23/2005 7:33:03 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET
Job Number :	24706		
Estimate Number :	10398		
P.O. Number :		Part Number :	D31561
This Issue :	11/23/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3156 REV B
First Issue :	/ /	Project Number :	
Previous Run :		Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :		Due Date :	11/30/2005
Comment :	Est A 04.11.30 New issue KJ/JLM	Qty:	4
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.4739 sf(s)/Unit Total : 1.8955 sf(s)
 Note: To be made in multiples of 10
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050)
 Batch: _____

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: 1.950" x 0.700" grain along 1.950"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA477 and Dwg D3156
 Stack of 10
 Identify as D3156-1

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

Date: Wednesday, 11/23/2005 7:33:03 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 24706

Part Number: D31561

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Form as per Dwg D3156

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion

